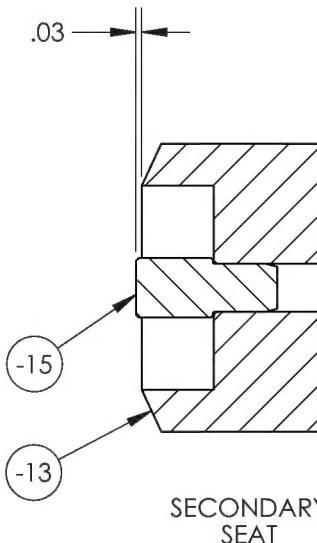
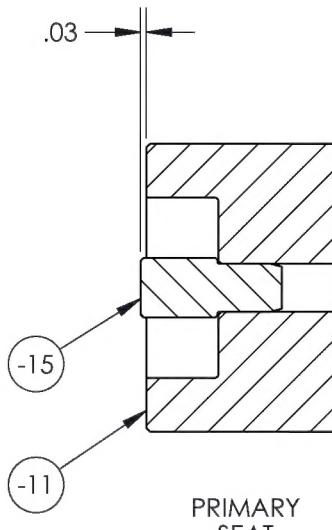
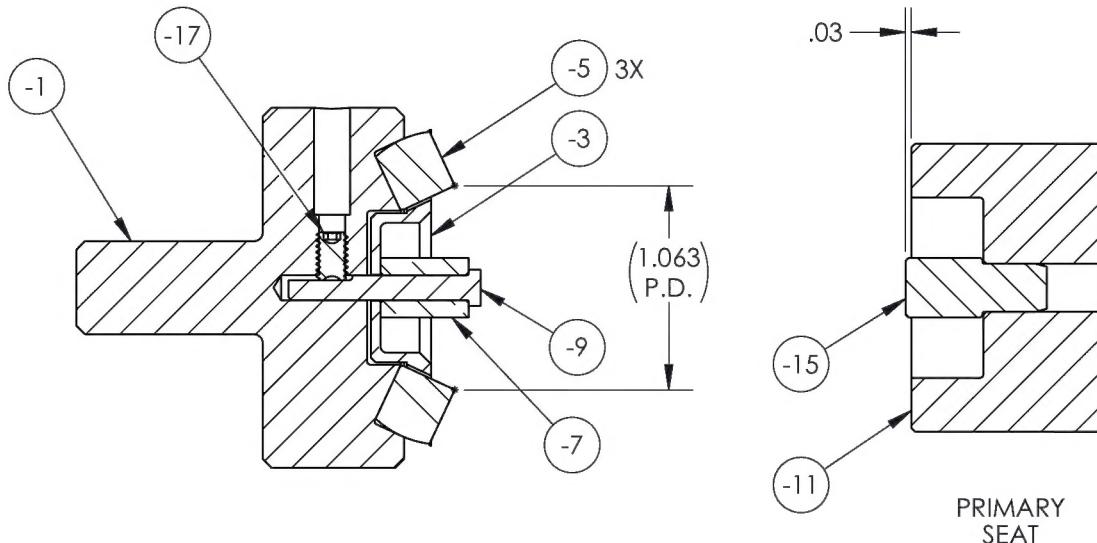
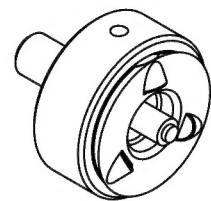


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			REVISIONS		
REV	ECR		DESCRIPTION	DATE	INITIAL
1			RELEASED FOR PRODUCTION.	4/6/2017	DPD JAG

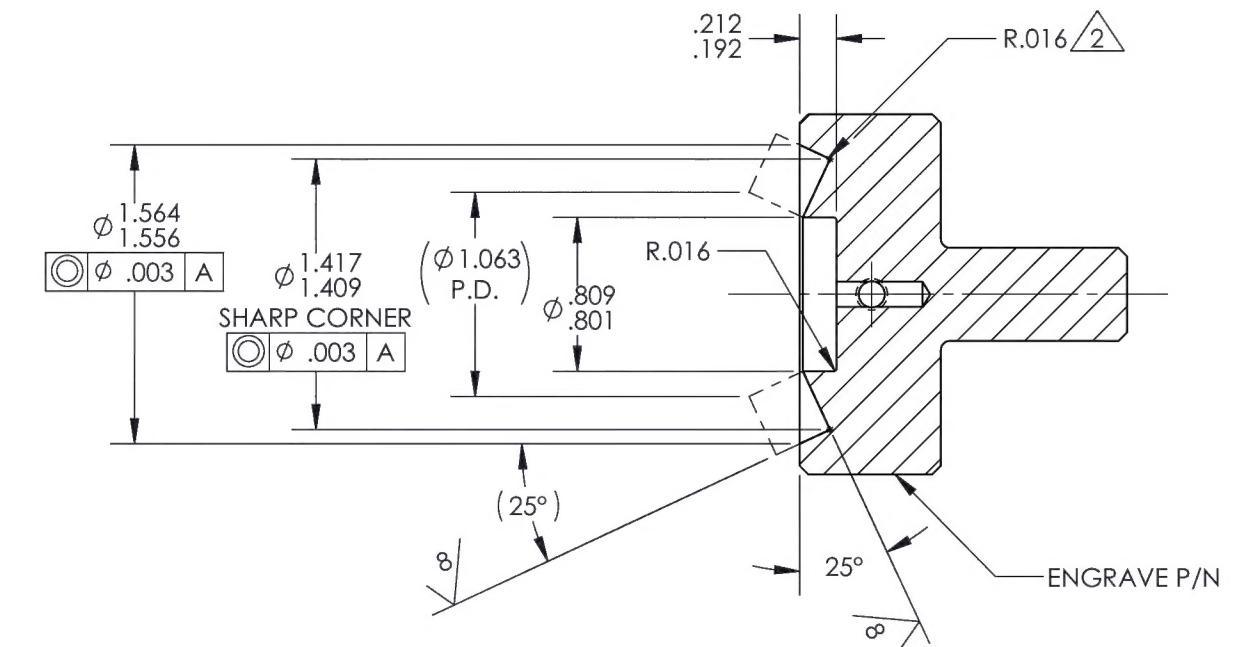
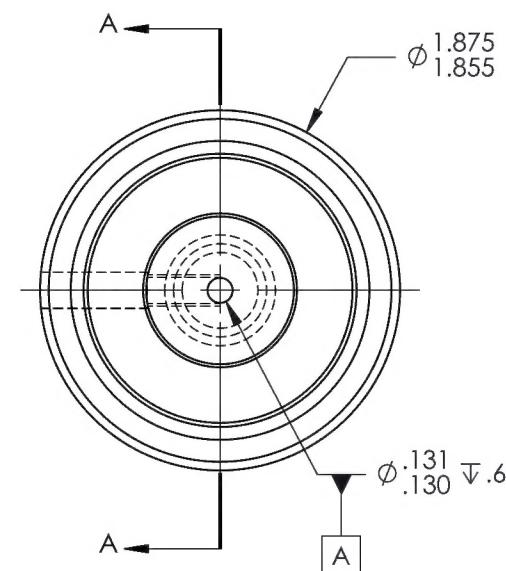
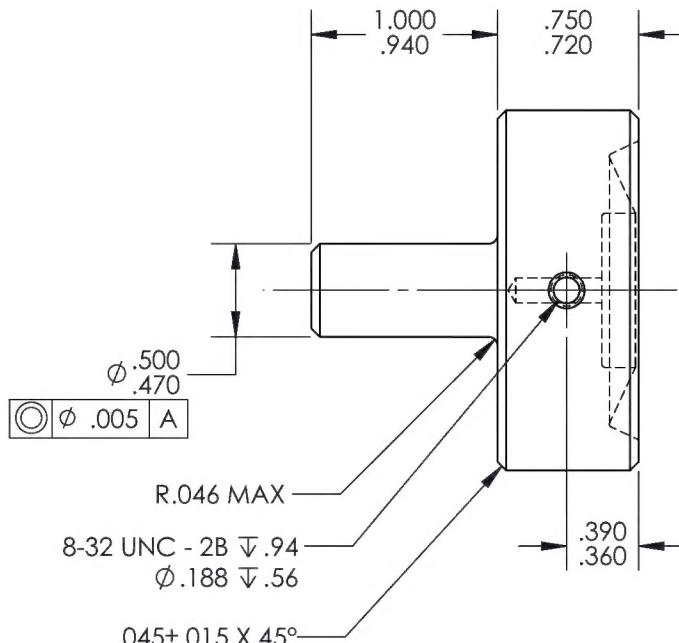
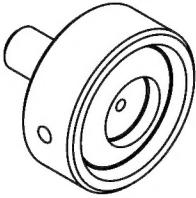


NOTE:
USED FOR BEARING 412-010-182-103.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	ROLLER FIXTURE	0-1 DRILL ROD		2
			-3	1	RETAINER	BRONZE		3
			-5	3	ROLLER	STEEL	Ø.031, CLASS ZZ, MINUS (GAUGE PIN MSC #89031009) MODIFIED	4
			-7	1	GUIDE	BRONZE		5
			-9	1	PIN	STEEL	Ø.129 X 2-1/2 (MCMASTER-CARR #98378A909) MODIFIED	6
			-11	1	PRIMARY SEAT	4140/4142		7
			-13	1	SECONDARY SEAT	4140/4142		8
			-15	2	LOCATING PIN	1018/1020 CR		9
		B/O	-17	1	SOCKET HEAD SET SCREW	S.S.	#8-32 X 1/4 (MCMASTER-CARR #97705A406)	1

TITLE		REV
DRILL PRESS SWAGING TOOL		1
DWG NO.		RBST4241
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125		
SPEC		
DRAWN BY:	DD 04/05/2017	
CHECKED:	SM 04/05/2017	
OPPS APPR:	AA 04/05/2017	
QA APPR:	JL 04/05/2017	
APPROVED:	JAG 04/06/2017	
SCALE	1:1	DATE 4/5/2017
USED ON MODEL		
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		
NOTE: USED FOR BEARING 412-010-182-103.		

REV		ECR		DESCRIPTION		DATE	INITIAL	APPROVED
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SECTION A-A

NOTES:

1. BREAK ALL SHARP CORNERS .015-.030
2. DIMENSION TO BOTTOM OF R.016=.153;
DIMENSION TO SHARP CORNER=.158.
3. DO FIRST ARTICLE INSPECTION BEFORE
HEAT TREATING.

(1)
ROLLER FIXTURE

DART AEROSPACE	
TITLE	
DRILL PRESS SWAGING TOOL	
DWG NO.	RBST4241-1
REV	1
MATERIAL	0-1 DRILL ROD
HEAT TREAT	RC 55-60
FINISH	ZINC PLATE
SPEC	QMSI-6.2.2, B.O. REV D
DRAWN BY:	DD 04/05/2017
CHECKED:	SM 04/05/2017
OPPS APPR:	AA 04/05/2017
QA APPR:	JL 04/05/2017
APPROVED:	JAG 04/06/2017
SCALE	1:1
DATE	4/5/2017
SHEET 2 OF 9	

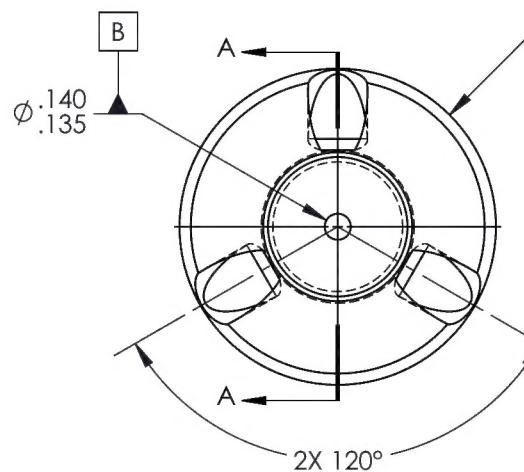
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

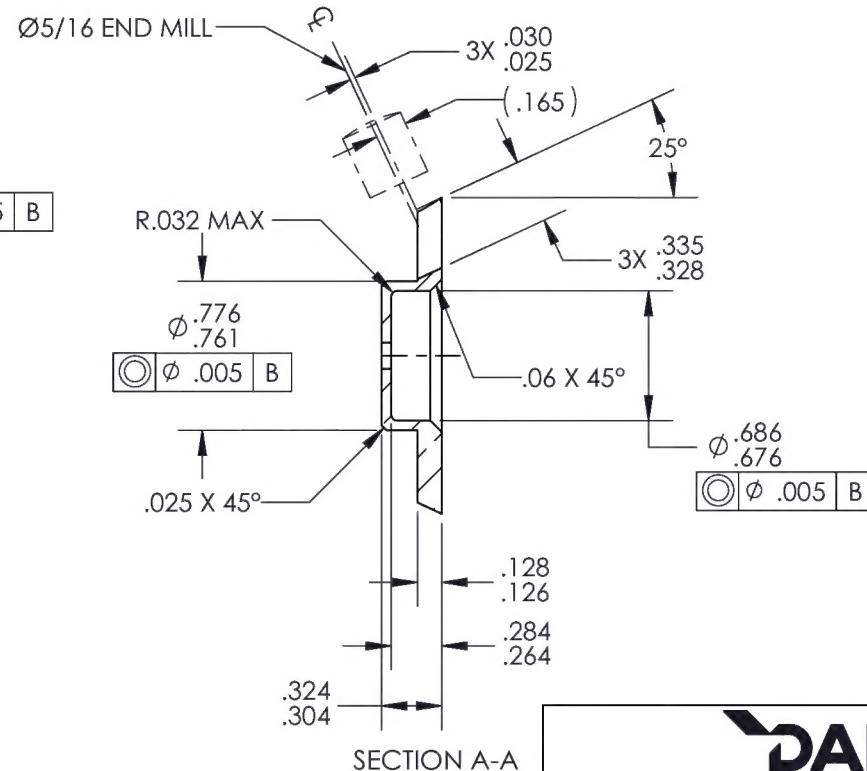
USED ON MODEL

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		DESCRIPTION	DATE	INITIAL
				APPROVED



RETAINER

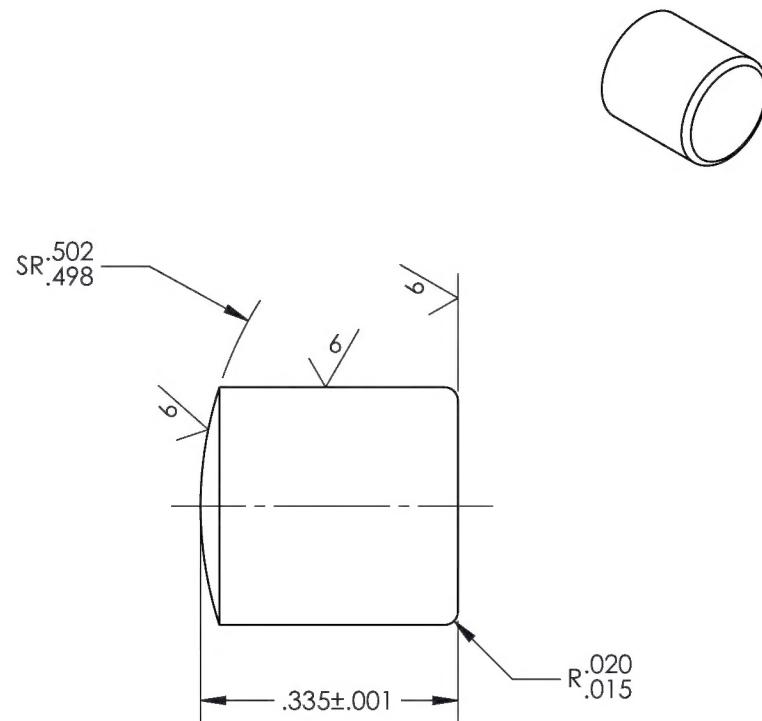
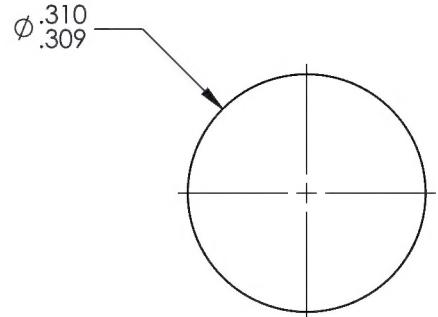


(-3)

DART AEROSPACE																																								
TITLE DRILL PRESS SWAGING TOOL																																								
DWG NO. RBST4241-3 REV 1																																								
<table border="1"> <tr> <td>MAT'L</td> <td>BRONZE</td> <td>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>HEAT</td> <td>.XXX ± .005</td> <td>FRACTIONS ± 1/8</td> </tr> <tr> <td>TREAT</td> <td>.XX ± .01</td> <td>ANGLES ± 5°</td> </tr> <tr> <td>FINISH</td> <td>X ± .1</td> <td>SURFACES = 125 ✓</td> </tr> <tr> <td colspan="3">SPEC</td> </tr> <tr> <td>DRAWN BY:</td> <td colspan="2">DD 04/05/2017</td> </tr> <tr> <td>CHECKED:</td> <td colspan="2">SM 04/05/2017</td> </tr> <tr> <td>OPPS APPR:</td> <td colspan="2">AA 04/05/2017</td> </tr> <tr> <td>QA APPR:</td> <td colspan="2">JL 04/05/2017</td> </tr> <tr> <td>APPROVED:</td> <td colspan="2">JAG 04/06/2017</td> </tr> <tr> <td>USED ON MODEL</td> <td colspan="2"></td> </tr> <tr> <td>SCALE</td> <td>1:1</td> <td>DATE 4/5/2017</td> </tr> <tr> <td colspan="2"></td> <td>SHEET 3 OF 9</td> </tr> </table>		MAT'L	BRONZE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	HEAT	.XXX ± .005	FRACTIONS ± 1/8	TREAT	.XX ± .01	ANGLES ± 5°	FINISH	X ± .1	SURFACES = 125 ✓	SPEC			DRAWN BY:	DD 04/05/2017		CHECKED:	SM 04/05/2017		OPPS APPR:	AA 04/05/2017		QA APPR:	JL 04/05/2017		APPROVED:	JAG 04/06/2017		USED ON MODEL			SCALE	1:1	DATE 4/5/2017			SHEET 3 OF 9
MAT'L	BRONZE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES																																						
HEAT	.XXX ± .005	FRACTIONS ± 1/8																																						
TREAT	.XX ± .01	ANGLES ± 5°																																						
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OPPS APPR:	AA 04/05/2017																																							
QA APPR:	JL 04/05/2017																																							
APPROVED:	JAG 04/06/2017																																							
USED ON MODEL																																								
SCALE	1:1	DATE 4/5/2017																																						
		SHEET 3 OF 9																																						

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REV		ECR		DESCRIPTION			DATE	INITIAL	APPROVED
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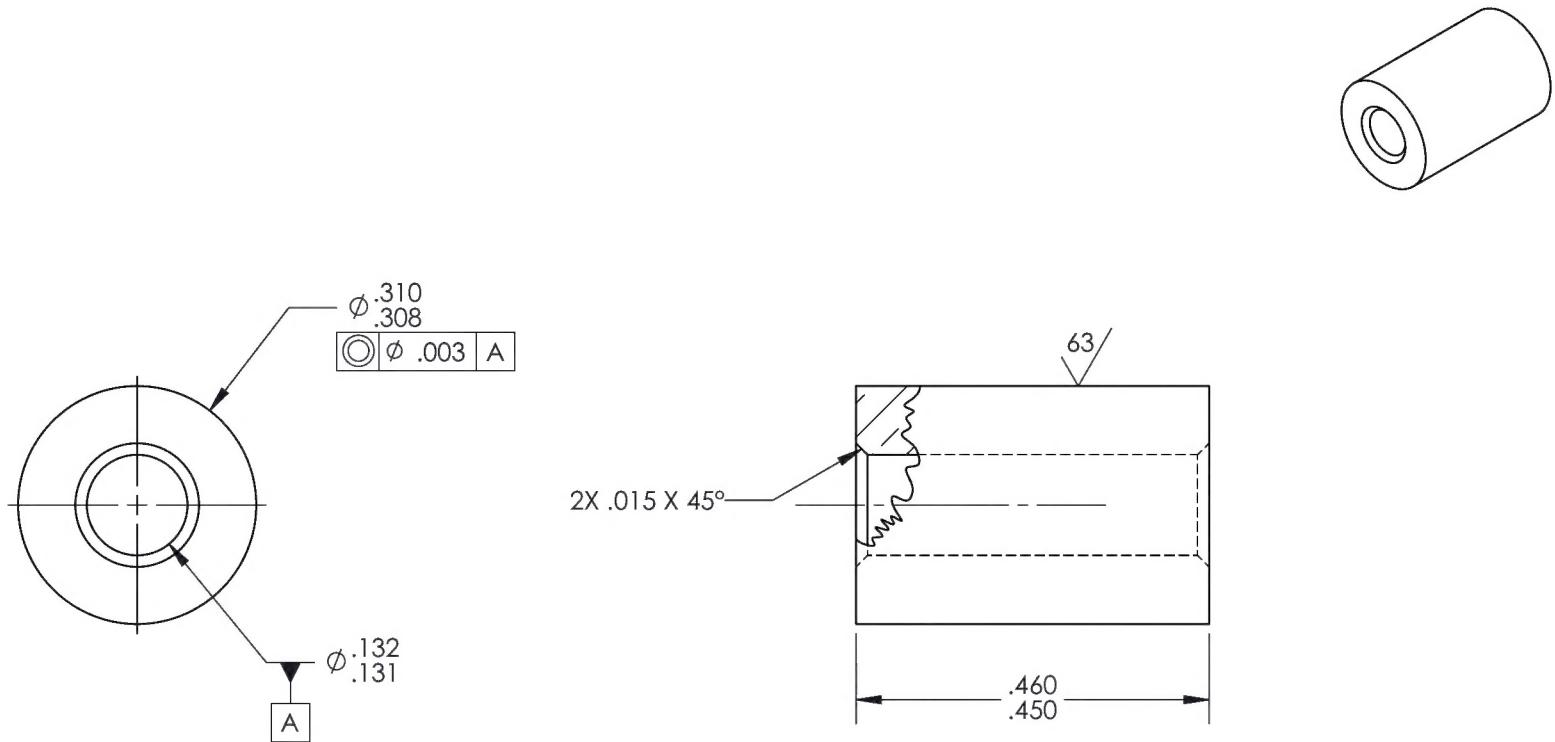
(-5)

ROLLER

DART AEROSPACE	
TITLE DRILL PRESS SWAGING TOOL	
DWG NO. RBST4241-5	
REV 1	
MATERIAL STEEL UNLESS OTHERWISE SPECIFIED HEAT RC 55-60 DIMENSIONS ARE IN INCHES TREAT FRACTIONS ± 1/8	
FINISH ANGLES ± 5°	
SPEC SURFACES = 125	
.XXX ± .005 .015 x 45° OR .015R ✓	
.XX ± .01 X ± .1	
DRAWN BY: DD 04/05/2017 CHECKED: SM 04/05/2017 OPPS APPR: AA 04/05/2017 QA APPR: JL 04/05/2017 APPROVED: JAG 04/06/2017 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL	
SCALE 4:1	DATE 4/5/2017
SHEET 4 OF 9	

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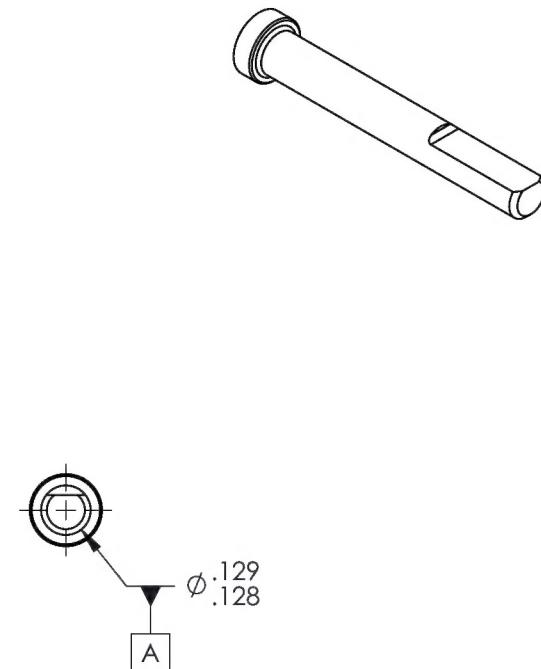
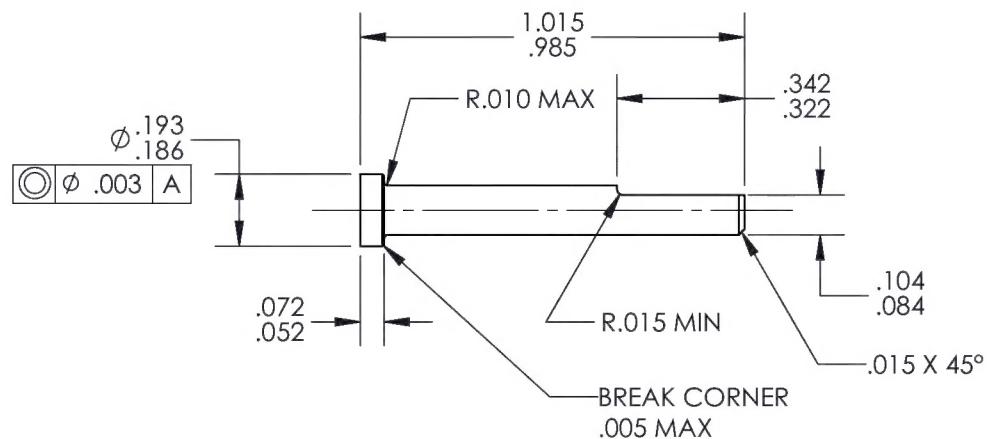
NOTE:
BREAK ALL SHARP CORNERS .015 - .030.



TITLE		DRILL PRESS SWAGING TOOL	REV
DWG NO.		RBST4241-7	1
MATERIAL			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT			.XXX ± .005 FRACTIONS ± 1/8
FINISH			.XX ± .01 ANGLES ± 5°
SPEC			X ± .1 SURFACES = 125
DRAWN BY:	DD 04/05/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:	SM 04/05/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:	AA 04/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:	JL 04/05/2017	USED ON MODEL	
APPROVED:	JAG 04/06/2017	SCALE	4:1
		DATE	4/5/2017
		SHEET	5 OF 9

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		DESCRIPTION	DATE	INITIAL
				APPROVED



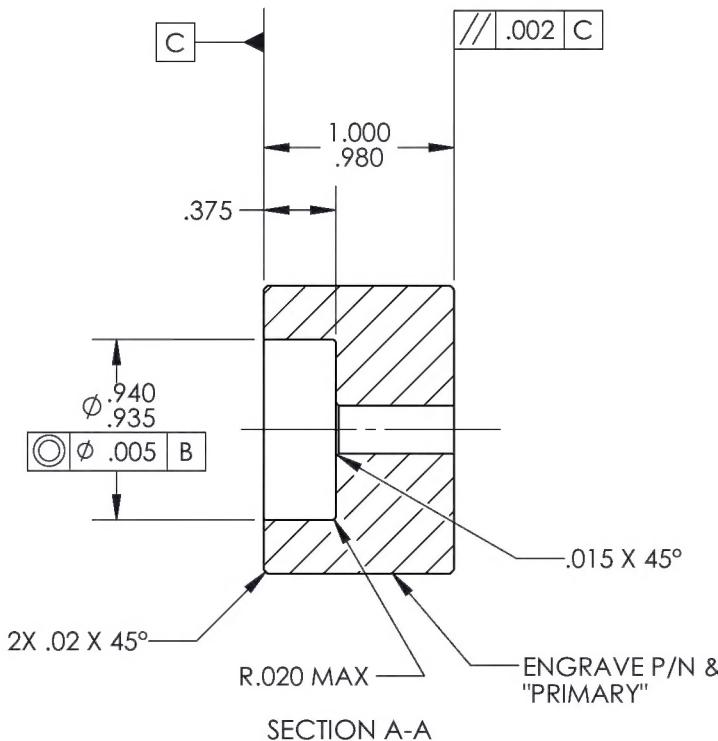
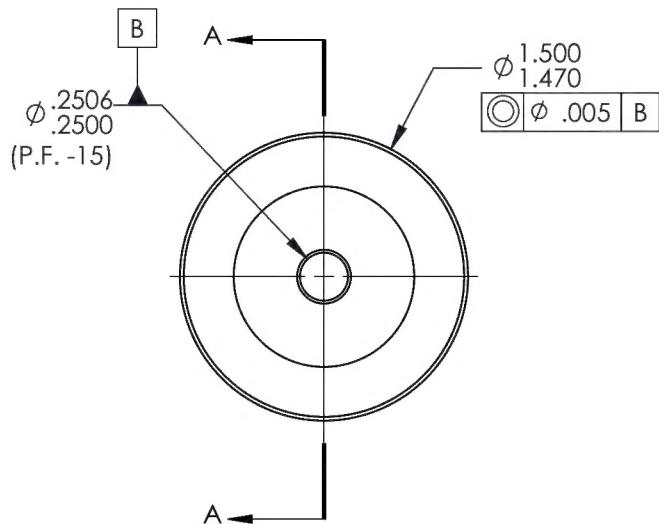
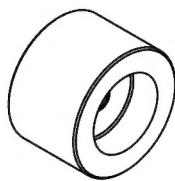
DART AEROSPACE	
TITLE DRILL PRESS SWAGING TOOL	
DWG NO. RBST4241-9 REV 1	
MATERIAL STEEL UNLESS OTHERWISE SPECIFIED HEAT FRACTIONS $\pm \frac{1}{16}$ TREAT ANGLES $\pm 5^\circ$ FINISH SURFACES = 125 SPEC QMSI-6.2.2, B.O. REV D	
DRAWN BY:	DD 04/05/2017
CHECKED:	SM 04/05/2017
OPPS APPR:	AA 04/05/2017
QA APPR:	JL 04/05/2017
APPROVED:	JAG 04/06/2017
SCALE	2:1
DATE	4/5/2017
SHEET 6 OF 9	

(-9)

PIN

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		DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A

NOTE:
BREAK ALL SHARP EDGES .015 - .030.



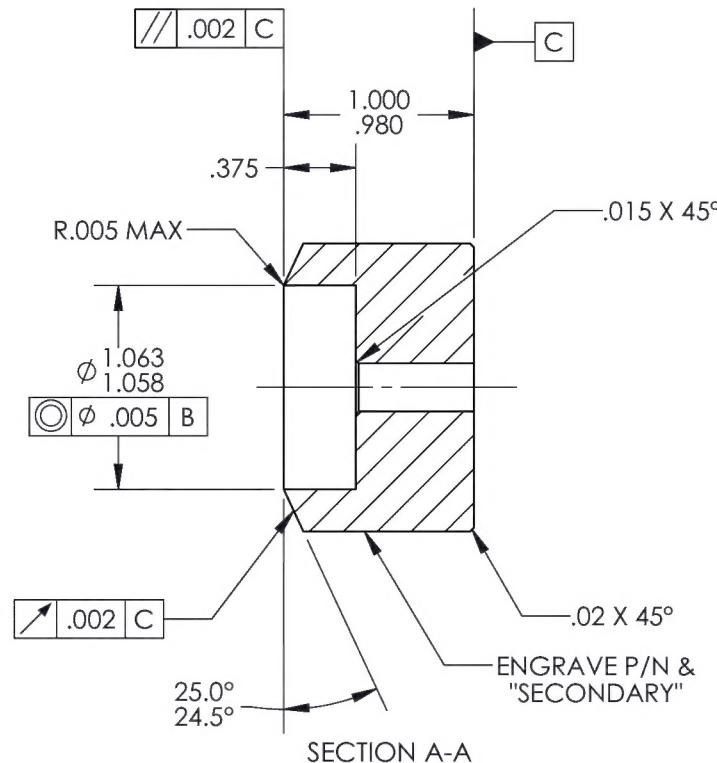
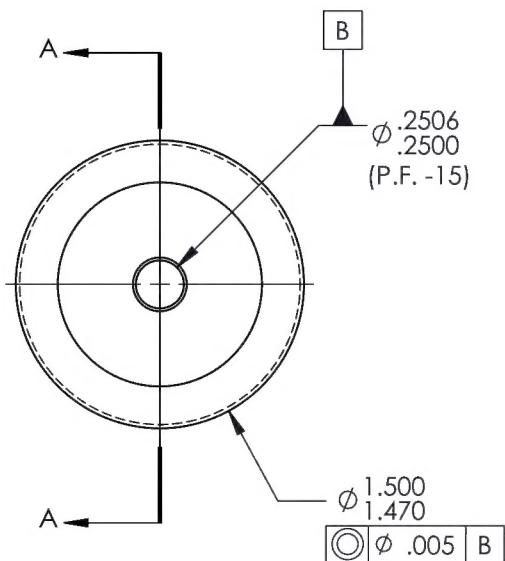
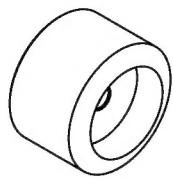
TITLE		DRILL PRESS SWAGING TOOL
DWG NO.		RBST4241-11
MAT'L	4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	RC 28-34	.XXX ± .005 FRACTIONS ± 1/8
TREAT		.XX ± .01 ANGLES ± 5°
FINISH	BLACK OXIDE	X ± .1 SURFACES = 125 ✓
SPEC	QMSI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	DD 04/05/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED:	SM 04/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR:	AA 04/05/2017	USED ON MODEL
QA APPR:	JL 04/05/2017	
APPROVED:	JAG 04/06/2017	
SCALE	1:1	DATE 4/5/2017
		SHEET 7 OF 9

(-11)

PRIMARY SEAT

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		DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A

NOTE:
BREAK ALL SHARP CORNERS .015 - .030.



TITLE DRILL PRESS SWAGING TOOL

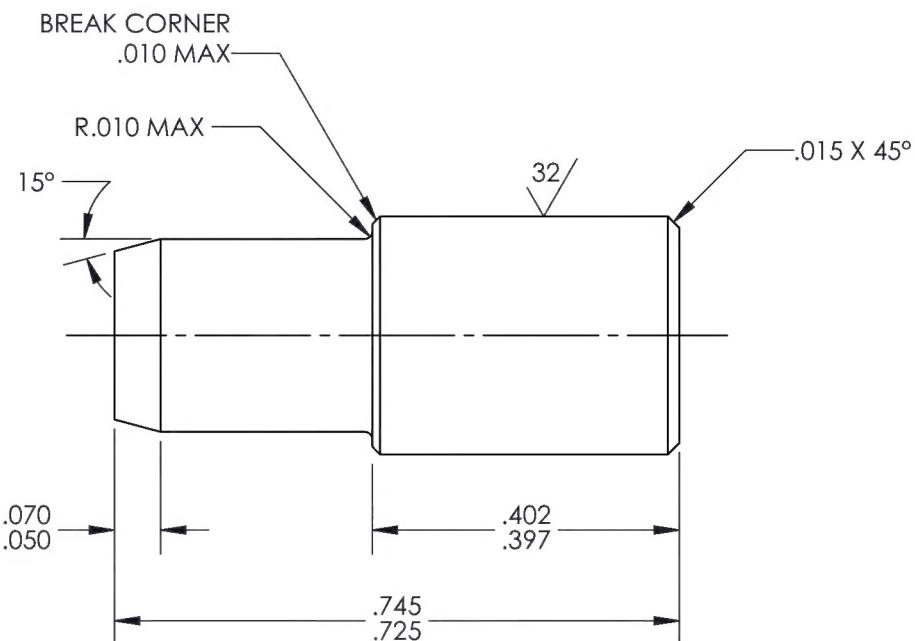
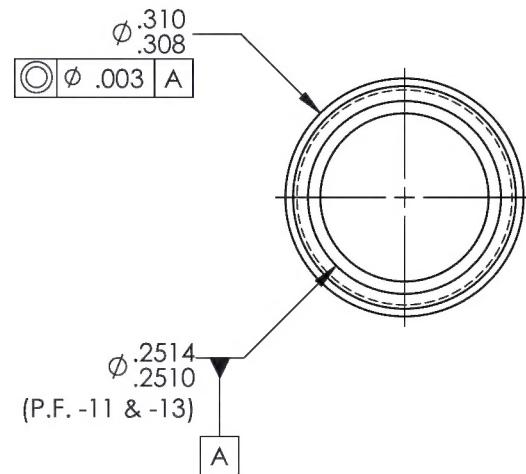
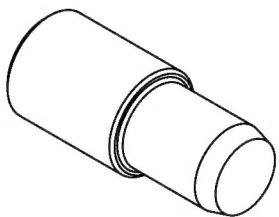
DWG NO.	RBST4241-13	REV 1
MATERIAL 4140/4142		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT RC 28-34		.XXX ± .005 FRACTIONS ± 1/8
TREAT		.XX ± .01 ANGLES ± 5°
FINISH BLACK OXIDE		X ± .1 SURFACES = 125
SPEC QMSI-6.2.2, B.O. REV D		✓
DRAWN BY:	DD 04/05/2017	
CHECKED:	SM 04/05/2017	
OPPS APPR:	AA 04/05/2017	
QA APPR:	JL 04/05/2017	
APPROVED:	JAG 04/06/2017	
SCALE 1:1	DATE 4/5/2017	SHEET 8 OF 9

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SECONDARY SEAT

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REV	ECR	REVISIONS		
		DESCRIPTION	DATE	INITIAL
				APPROVED



TITLE DRILL PRESS SWAGING TOOL		
DWG NO.	RBST4241-15	
MAT'L	1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .005	FRACTIONS ± 1/8
TREAT	.XX ± .01	ANGLES ± 5°
FINISH	X ± .1	SURFACES = 125 ✓
SPEC	QMSI-6.2.2, B.O. REV D	
DRAWN BY:	DD 04/05/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED:	SM 04/05/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	AA 04/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	JL 04/05/2017	USED ON MODEL
APPROVED:	JAG 04/06/2017	
SCALE	4:1	DATE 4/5/2017
		SHEET 9 OF 9

(-15)

LOCATING PIN